

Work Order ID 57824

April 16, 2010 10:51:44 AM

Page 1

Item ID: D3909-1

Accept

Revision ID:

Item Name: Lug Plate, Fwd Crosstube

Start Date: 16/04/2010 Start Qty: 12.00

Required Date: 29/04/2010 Req'd Qty: 12.00

Reference: *Final 10.04.16*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D3909

B

100

0.00



Waterjet

FLOW CNC Waterjet

304 .126

Memo

0.00

Cut as per dwg D3909

Prog Rev: *3*

Dwg Rev: *B*

Deburr as required

B10-4-19

(12)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Deburr = 7 m-l w/04/10

(12x)

B10-4-19



Lean Is...

- “LEAN IS – from an operations perspective... a system that cuts costs & inventories rapidly to free cash, which is critical in a slow economy. It also supports growth by improving productivity and quality, reducing lead times and freeing huge amounts of resources.
- Lean aims at reducing (if not eliminating) none value added activities in business processes.
- It's not a project.

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Item ID: D3909-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Lug Plate, Fwd Crosstube

Start Date: 16/04/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 29/04/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8 10/04/13

412

150

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

10-4-21 sf 12x

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/22 HJ

ME 10-4-22



Lean is...

- Promote customer-orientation rather than resource-orientation (produce for sales not for stock).
- A highly evolved method of managing an organization to improve the productivity, efficiency and quality of its products or services.
- Transforms how the company operates and how employees think about their work. Don't work harder but smarter by transferring your energy from the NVA to the VA activities.
- Has no end (there is no "done").

Picklist Print

April 16, 2010 10:51:43 AM

Page 1

Work Order ID: 57824

Parent Item: D3909-1

Parent Item Name: Lug Plate, Fwd Crosstube

Comments: IPP RevA: new issue DD 09.11.17 verified by:EC IPP RevB: as per revPA3
DD verified by:EC

Start Date: 16/04/2010

Required Date: 29/04/2010

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	20.2000	2.4632			



304/316 0.125 Sheet



18 10-4-19

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT19	20.2	
112663	20.2	

112663



Lean Is...

“LEAN IS... A mindset, or way of thinking

- A commitment to achieve a totally waste-free operation focused on the customer's success
- Achieved by simplifying and continuously improving all processes and relationships in an environment of trust, respect and full employee involvement
- It is about people, simplicity, flow, visibility, partnerships and true value as perceived by the customer.”

DART AEROSPACE LTD	Work Order: 57824
Description: Lug PLATE End CROSSTUBE	Part Number: D3909-1
Inspection Dwg: D3909-1, Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ ~~Prototype~~

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.133	*			
Ø .191	+ .005 - .001	.194	*			
Ø .266	+ .006 - .001	.266	*			
Ø .38	+ .006 - .001	.380	*			
.75	± .030	.757	*			
1.14	± .030	1.14	*			
.22	± .030	.22	*			
2.34	± .030	2.344	*			
7.02	± .030	7.021	*			
8.02	± .030	8.030	*			
.38	± .030	.381	*			
.625	± .010	.625	*			
.750	± .010	.753	*			
.375	± .010	.377	*			
3.50	± .030	3.508	*			
.70	± .030	.704	*			
3.14	± .030	3.135	*			
.610 .611	± .010	.608	*			
.625	± .010	.624	*			
1.75	± .030	1.749	*			
7.141	± .020	7.142	*			
.125	± .010	.117	*			

Measured by: RB
Date: 10-4-19

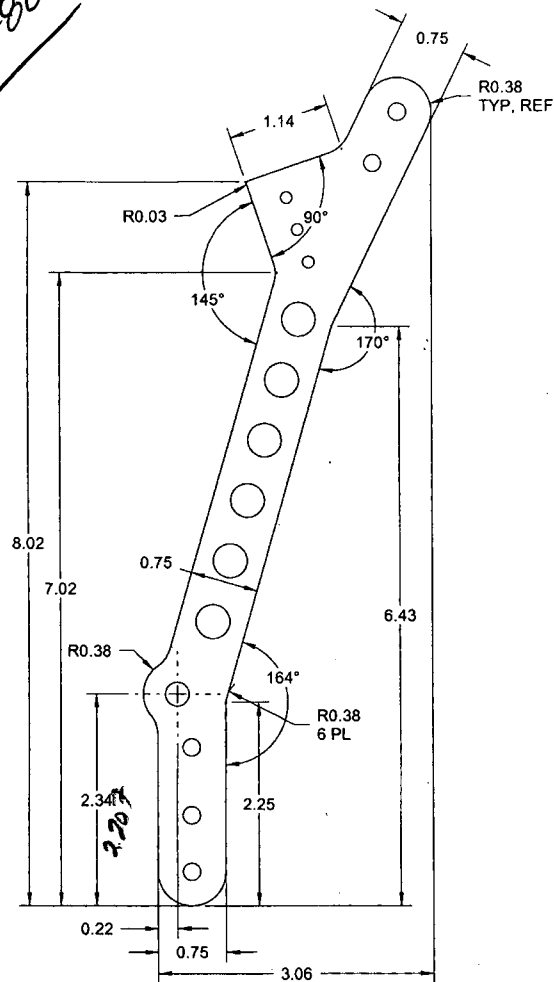
Audited by: S
Date: 10/04/19

Prototype Approval: 1/A
Date: 1/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





9.17

0.125
REF

[illegible]

RELEASED
2010-04-07
mf

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.25 lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3909	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		FWD X-TUBE LUG ASSY	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Lean principle

To be able to produce exactly:

- **what is required**
- **when it is required**
- **the quantity required**

by the next step in the process.

Once a job started, it should ideally never stop